

Work Order ID 86040

86040

Page 1

June-19-12 4:09:15 PM

Item ID: D3783-043

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Longitudinal Brace Assembly

Stop *NS2*

Start Date: 19/06/2012 Start Qty: 2.00 *2*

Cust Item ID:

Required Date: 03/07/2012 Req'd Qty: 2.00 *2*

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 12/06/20 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3783	Rev A								
100	Pick Kit	0.00							
100									
Packaging	Memo	0.00							
Packaging									
110	Small Fab	0.00							
110									
Small Fab	Memo	0.00							
Small Fab	1-assemble as per dwg D3783								
120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.00							
Quality Control									

SMB
12-9-19

DAS
12/6/20

2

FF
12-09-19

2

FF
12-09-19

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item Name: Longitudinal Brace Assembly

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2

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Required Date: 03/07/2012 Req'd Qty: 2.00

2


Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>249A</u>	0.00							
130									
Packaging	Memo	0.00				2		82	12/9/21
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

12/9/24 MK
12-09-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

June-19-12 4:09:19 PM

Page 1

Work Order ID: 86040

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Parent Item: D3783-043

D3783-043

Parent Item Name: Longitudinal Brace Assembly

Start Date: 19/06/2012

Required Date: 03/07/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 08-05-19 new issue DD verified by:ec
IPP Rev:B 08-06-17 rev.a as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN5-13A		Purchased	No			110	Each	88.0000	1	2			
AN5-13A													
Bolt													

Location	Loc Qty	Loc Code
GA	10	
116003	10	
ST338	78	
108167	8	
118983	4	
121181	50	
15928	16	
		2

AN960JD516	NAS1149D0563J	Purchased	No			110	Each	16.0000	2	4			
AN960JD516													
Washer													

Location	Loc Qty	Loc Code
ST338 121255	16	
2612	16	
		4

D3765-1		Manufactured	No			110	Each	8.0000	1	2			
D3765-1													
Clevis													

Location	Loc Qty	Loc Code
ST243 85914	4	
83374	4	
ST250	4	
81698	4	
		2

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

June-19-12 4:09:19 PM

Page 2

Work Order ID: 86040

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Parent Item: D3783-043

D3783-043

Parent Item Name: Longitudinal Brace Assembly

Start Date: 19/06/2012

Required Date: 03/07/2012

Start Qty: 2.00

Required Qty: 2.00

D3769-3

Manufactured No

110

Each

2.0000

1

2

D3769-3

Tube

**

② FF 12-09-19

Location

Loc Qty

Loc Code

ST251A

2

65062

2

2

MS21042L5

Purchased

No

110

Each

1,335.000

1

2

MS21042L 5

Nut

**

② FF 12-09-19

Location

Loc Qty

Loc Code

300

500

121652

500

ST300

835

108827

4

116105

5

116548

43

117611

18

119109

749

17651

8

2937

8

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

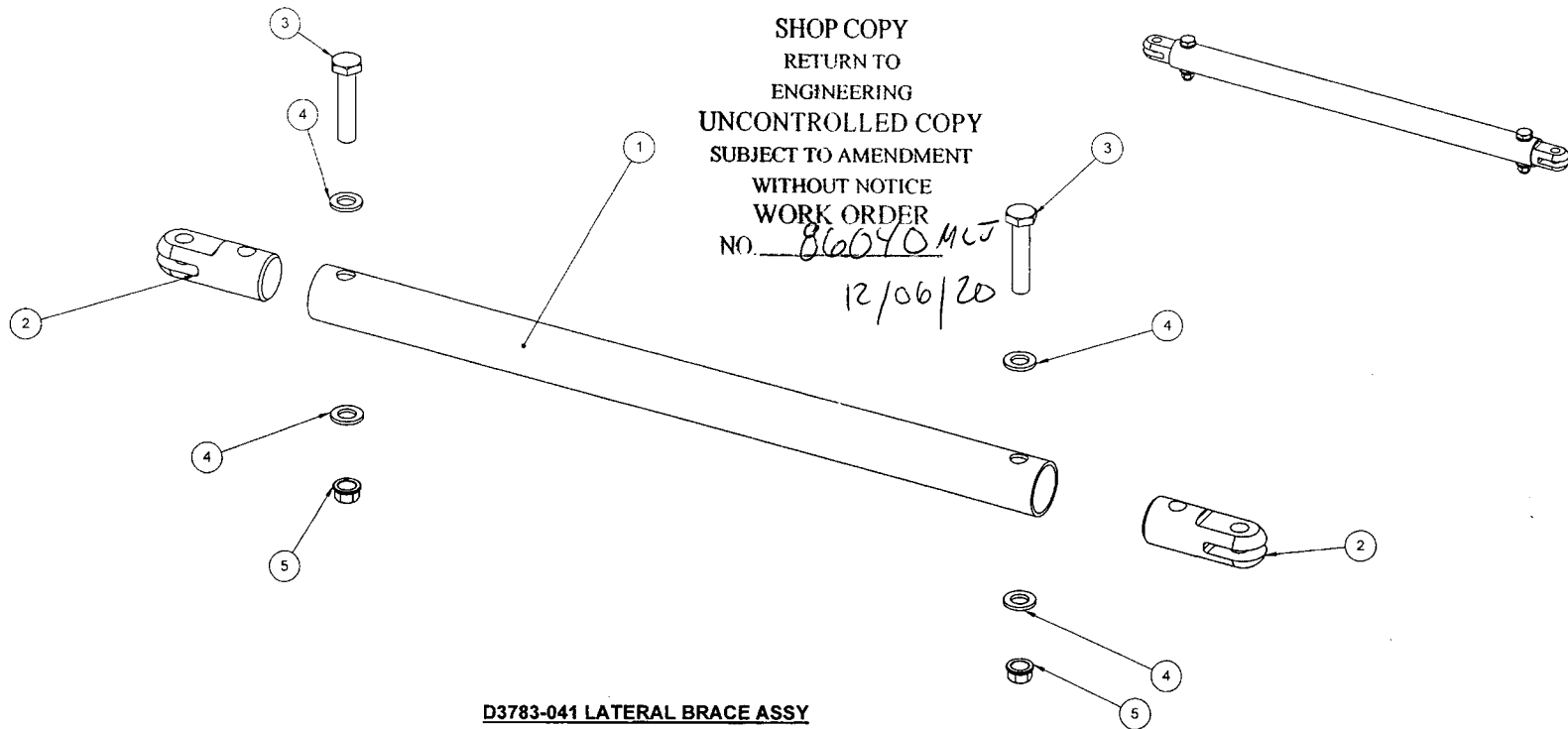
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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 ENGINEERING
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 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 86040 MCT
 12/06/20



D3783-041 LATERAL BRACE ASSY

ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-041)
1	D3769-1	TUBE	1
2	D3765-1	CLEVIS	2
3	ANS-13A	BOLT	2
4	NAS1149D0568J	WASHER (AN960JD516)	4
5	MS21042L5	NUT	2

RELEASED
 08-06-16/10

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.52 lbs

A		NEW ISSUE		HS	08.06.04
REV	DESCRIPTION			BY	DATE
DESIGN	HS			DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.	[Signature]			D3783	SHEET 1 OF 3
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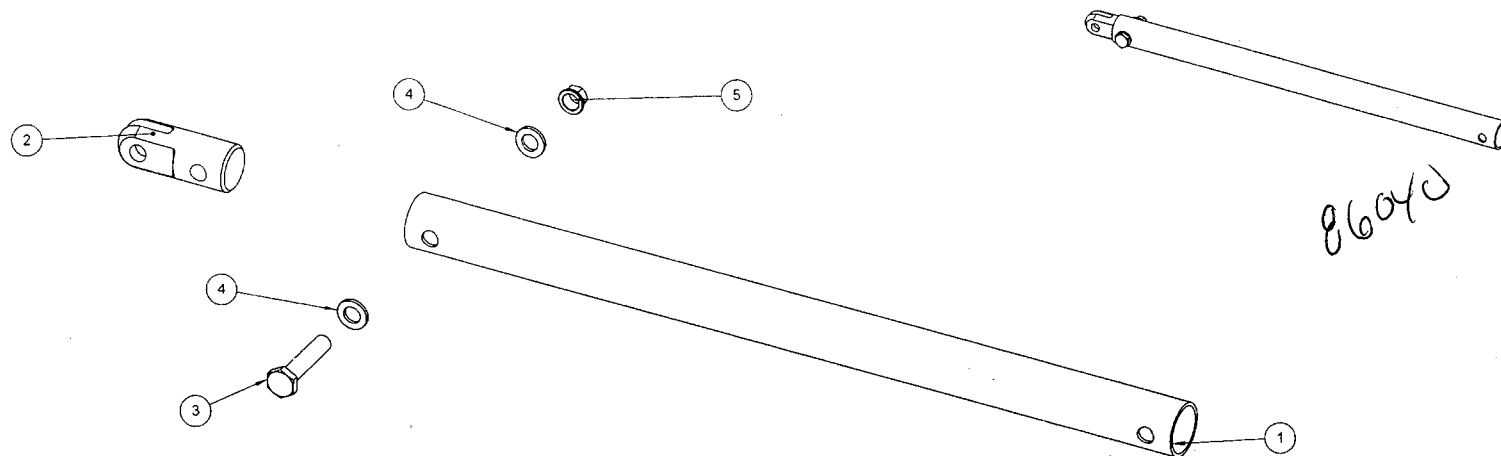
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3783-043 LONGITUDINAL BRACE ASSY

ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-043)
1	D3769-3	TUBE	1
2	D3765-1	CLEVIS	1
3	ANS-13A	BOLT	1
4	NAS1149D0568J	WASHER (AN960JD516)	2
5	MS21042L5	NUT	1

RELEASED
06-06-16

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.41 lbs

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APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BRACE ASSEMBLY	NTS
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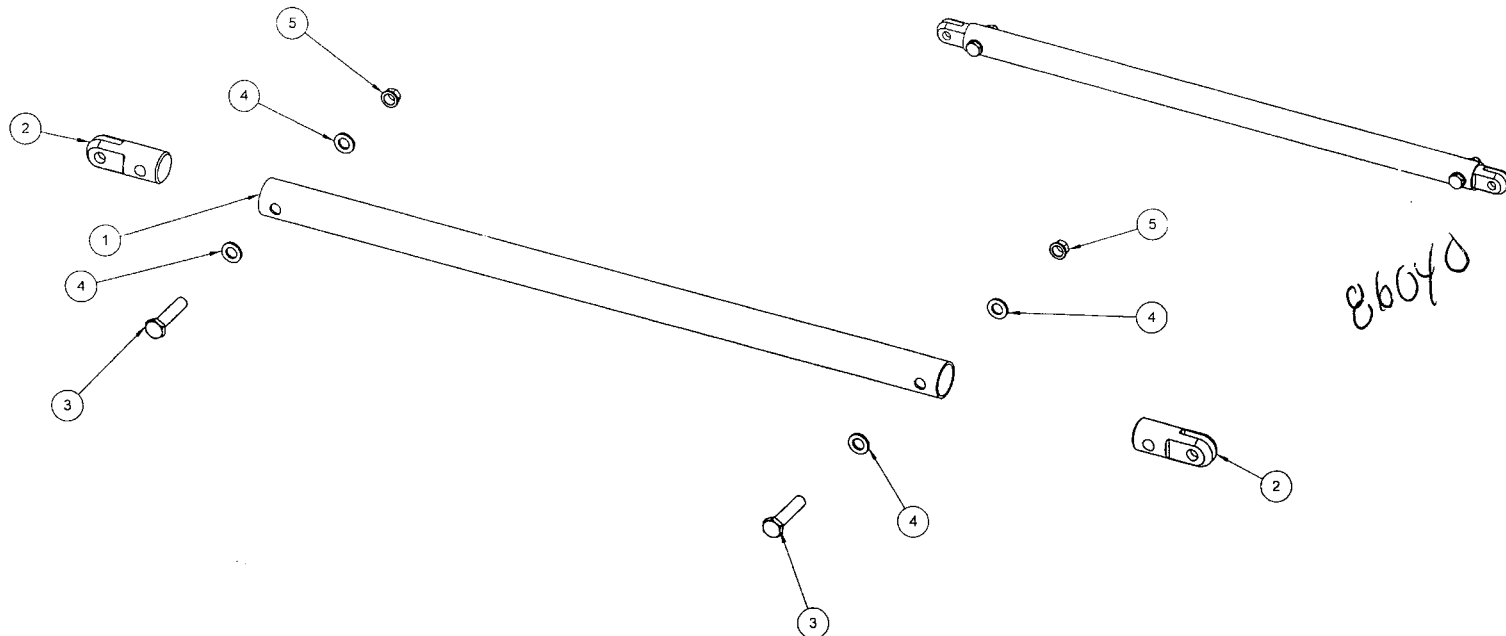
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3783-045 ANGLE BRACE ASSY

ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-045)
1	D3769-5	TUBE	1
2	D3765-1	CLEVIS	2
3	AN5-13A	BOLT	2
4	NAS1149D0568J	WASHER (AN960JD516)	4
5	MS21042L5	NUT	2

RELEASED
08-06-14

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.63 lbs

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MFG. APPR.	<i>[Signature]</i>	D3783	SHEET 3 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries